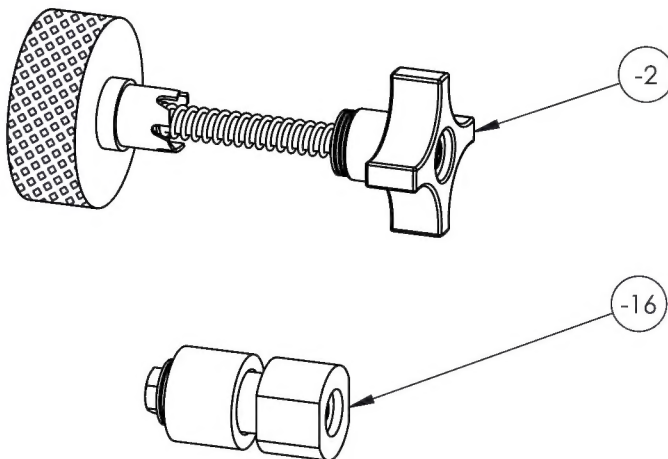


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/2004	-	-
2		CH'D NOTE P/N -7 TURN TO FROM .660 PER GABRIEL. CH'D REVISIONS TO NUMERICAL. CH'D TITLEBLOCK & REVISION BLOCK. MADE SECTION VIEW A-A P/N -6, LABELED SECTIONS B-B P/N -17, & SECTION C-C P/N -21.	7/27/2009	RJC	-
3	15-0104	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIM WAS Ø.501 IS Ø.5012-.5016. ADDED DIM .10. DELETED TAPER. DELETED DIM 2.000. ADDED DIM 2.50. ADDED MIN. RELIEF. -10 CH'D B/O INFO WAS EUGENE FASTENER #16 IS MCMMASTER-CARR #9657K122. -11 ADDED QTY 2 TO -16 ASSY. -13 ADDED QTY 1 TO -16 ASSY. -17 DELETED DIMS .493, .420. ADDED DIM 43.6°. CORRECTED TYPO ON THREAD CALLOUT. -19 ADDED B/O INFO #97633A130. -23 & -25 DELETED. -27 CH'D DIM WAS .030 IS .030 +.005 -.000. ADDED B/O INFO #91247A014. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/13/2015	DPD	JAG

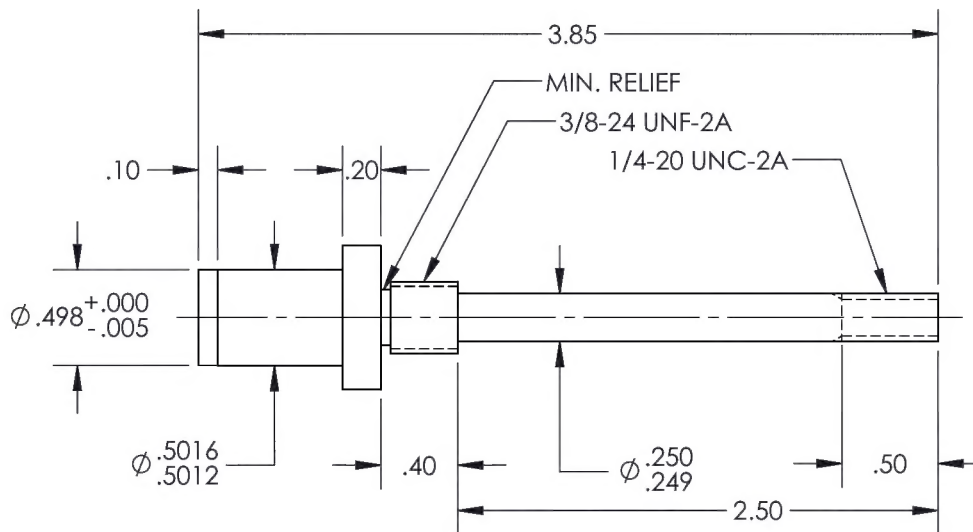
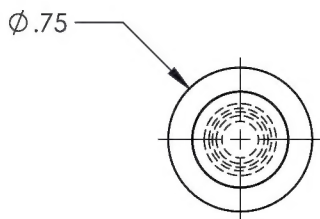
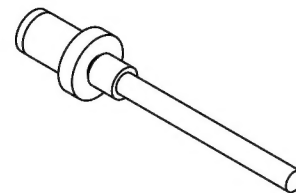


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	1		-1		SHAFT	STRESSPROOF		2
	X		-2	1	CUTTER ASSEMBLY			3
	1		-3		HANDLE	6061 T6		4
	1		-7		6 TOOTH CUTTER	0-1		5
	1	B/O	-10		SPRING	STEEL	Ø.437 OD X Ø.054 WIRE X 2, 15.54 LBS./IN. (MCMMASTER-CARR #9657K122)	3
2	2	B/O	-11		WASHER	STEEL	TRA-411 (APPLIED INDUSTRIAL)	3 & 6
1	1	B/O	-13		BEARING	Alloy Steel	NTA-411 (APPLIED INDUSTRIAL)	3 & 6
	1	B/O	-15		KNOB		1/4-20 (ESSENTA COMPONENTS #DK-54)	3
X			-16	1	REMOVE & INSTALL TOOL			6
1			-17		R & I ADAPTER	STRESSPROOF		7
1		B/O	-19		SNAP RING	STEEL	Ø1/4 (MCMMASTER-CARR #97633A130)	6
1			-21		CAP	6061 T6		8
1			-27		BOLT	STEEL	1/4-28 X 1-3/4 (MCMMASTER-CARR #91247A014) MODIFIED	9
ASSY -16	ASSY -2							



TITLE		DAMPER BEARING TOOL KIT	
DWG NO.	RB877528-4		REV 3
MAT'L	DRAWN BY: PERRITT		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005	FRACTIONS ± 1/8	HEAT TREAT	
.XX ± .01	ANGLES ± 5°	FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45°		USED ON MODEL	
OR .015R		MD 500D	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:2	DATE 6/28/2000	SHEET 1 OF 9	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0104	-1 CH'D DIM WAS Ø.501 IS Ø.5012-.5016. ADDED DIM .10. DELETED TAPER. DELETED DIM 2.000. ADDED DIM 2.50. ADDED MIN. RELIEF.	5/13/2015	DPD	JAG



①

SHAFT



TITLE	DAMPER BEARING TOOL KIT
-------	-------------------------

DWG NO.	RB877528-4-1
---------	--------------

REV	3
-----	---

MAT'L STRESSPROOF

DRAWN BY: PERRITT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

APPROVED	<i>D Weil</i>
----------	---------------

XXX ± .005 **FRACTIONS ± 1/8**
XX ± .01 **ANGLES ± .5°**
X ± .1

HEAT	
TREAT	
FINISH	BLACK OXIDE

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

5° R	SPEC
	USED ON MODEL
	MD 500D

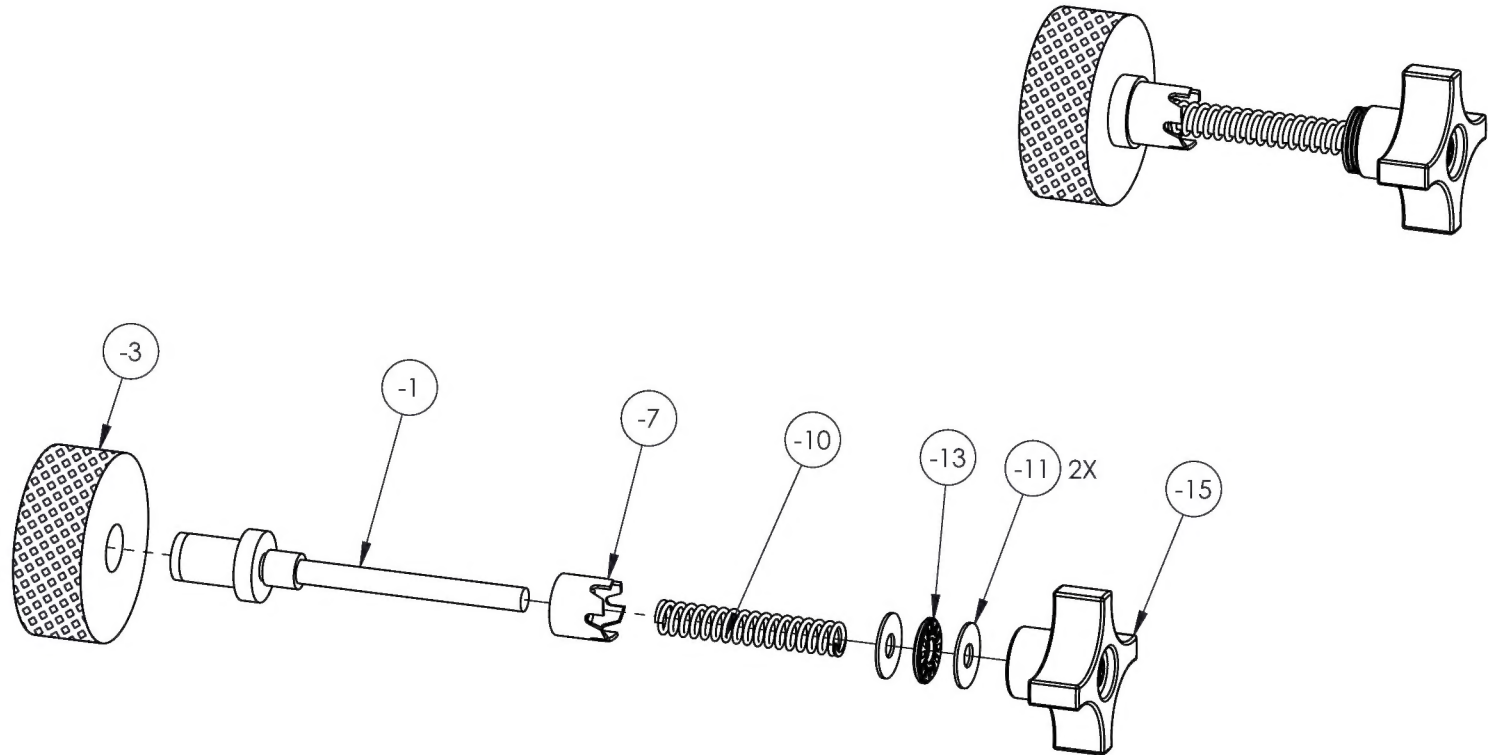
SCALE 1:1

DATE	6/28/2000
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SHEET 2 OF 9

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

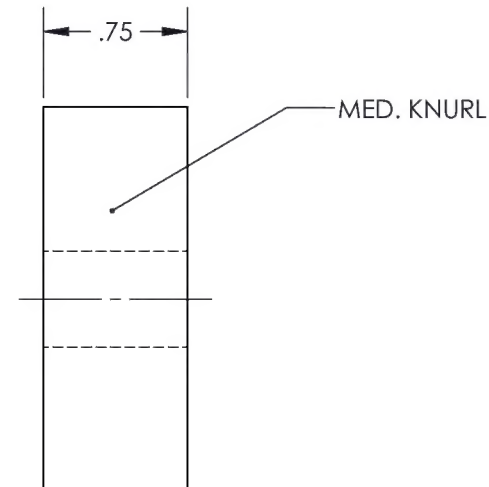
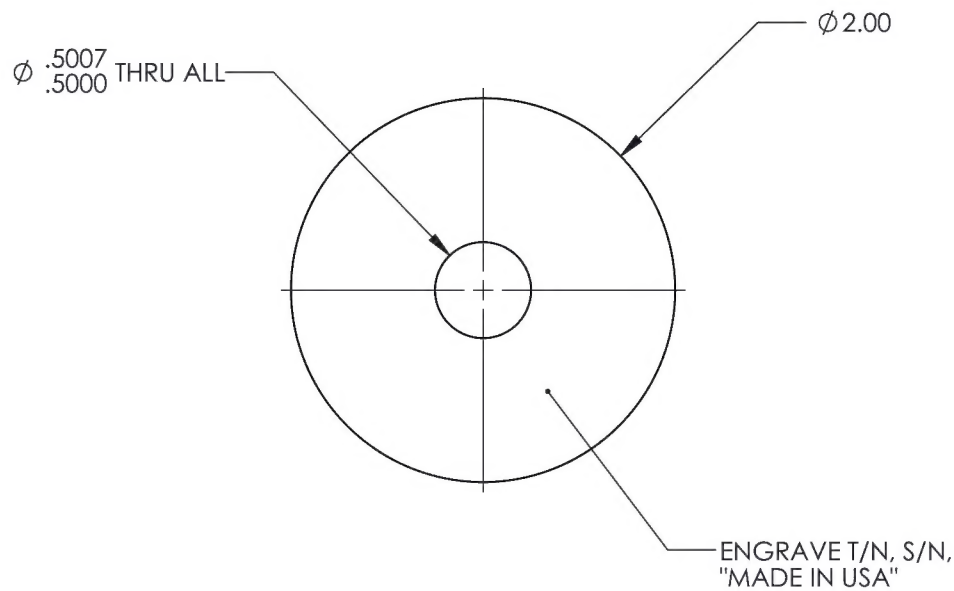
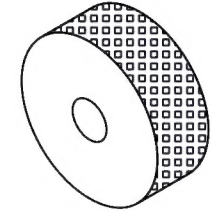


(-2)
CUTTER ASSEMBLY

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-2	REV 3
MAT'L	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	MD 500D
SCALE 1:2	DATE 6/28/2000
	SHEET 3 OF 9

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

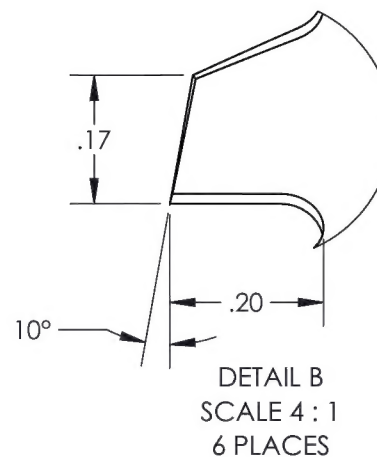
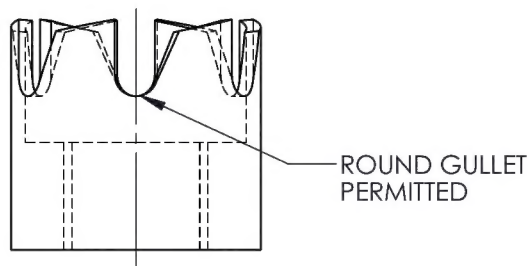
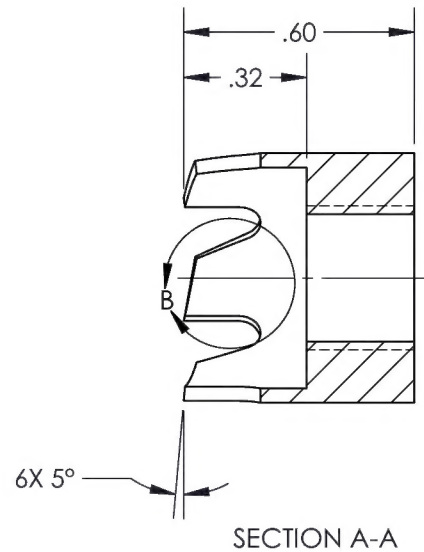
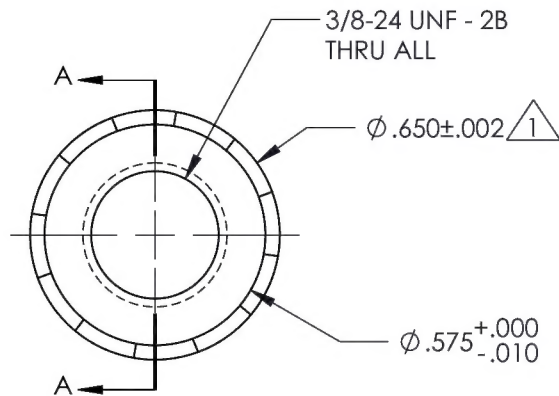


(-3)
HANDLE

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-3	REV 3
MAT'L 6061 T6	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	MD 500D
SCALE 1:1	DATE 6/28/2000
SHEET 4 OF 9	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/2004	-	-
2		CH'D NOTE TURN TO FROM .660 P/N -7 PER GABRIEL. CH'D REVISIONS TO NUMERICAL. CH'D TITLEBLOCK & REVISION BLOCK, MADE SECTION VIEW A-A P/N -6, LABELED SECTIONS B-B P/N -17, & SECTION C-C P/N -21.	7/27/2009	RJC	-



⑦
6 TOOTH CUTTER

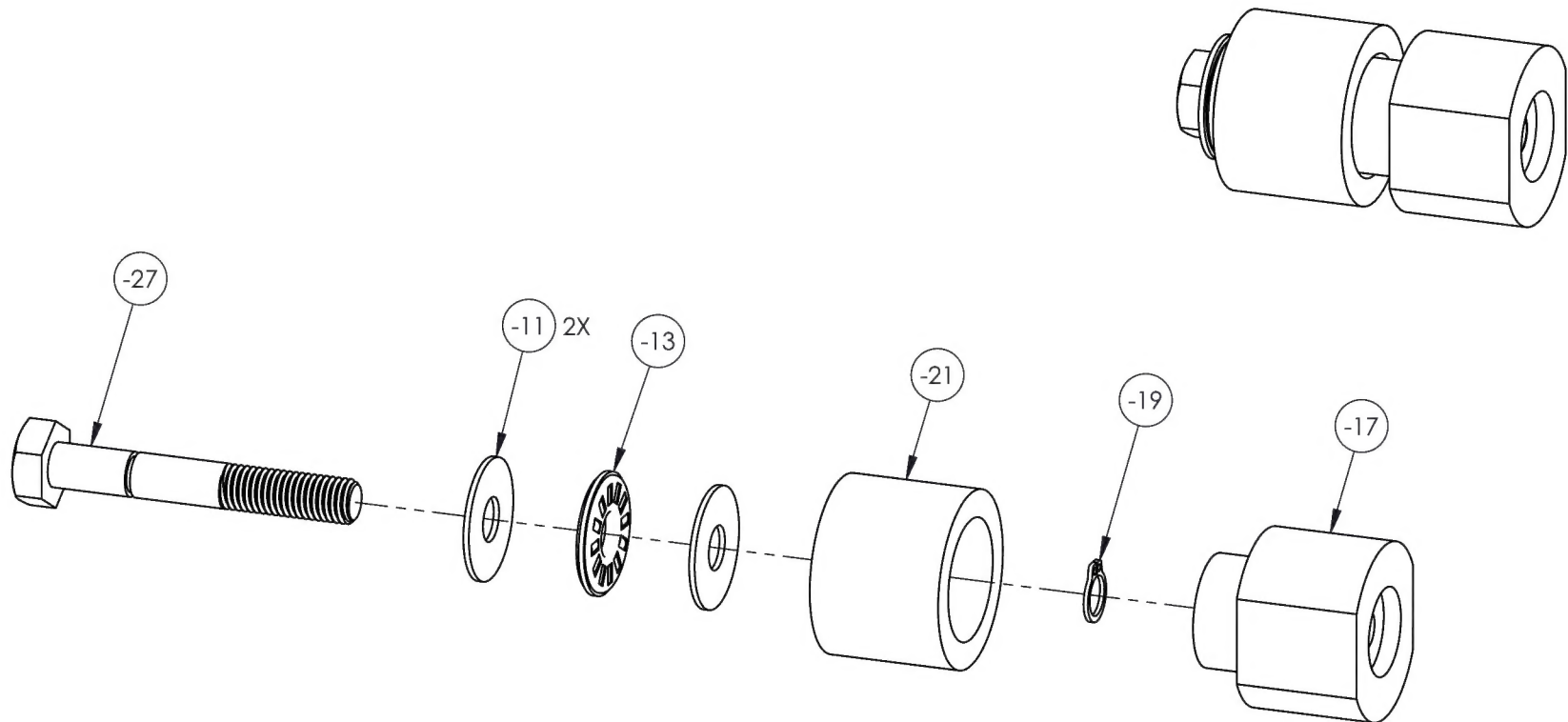
NOTE:

① LEAVE OD .010 TO .015 OVER SIZED.
GRIND AFTER HEAT TREAT.

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-7	REV 3
MAT'L 0-1	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT RC 50-60
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	MD 500D
SCALE 2:1	DATE 6/28/2000
SHEET 5 OF 9	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



-16

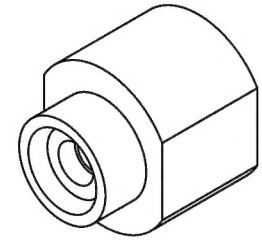
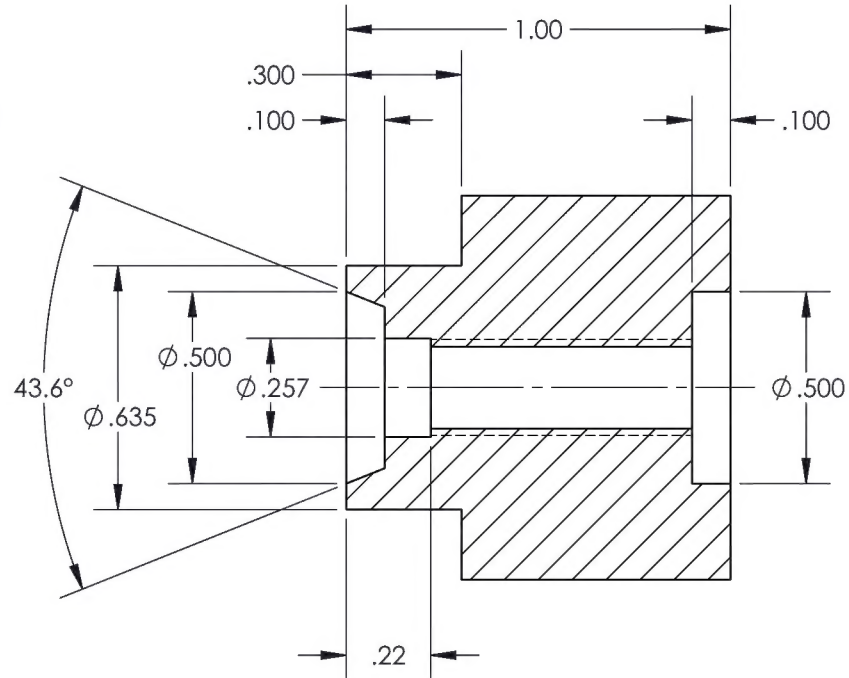
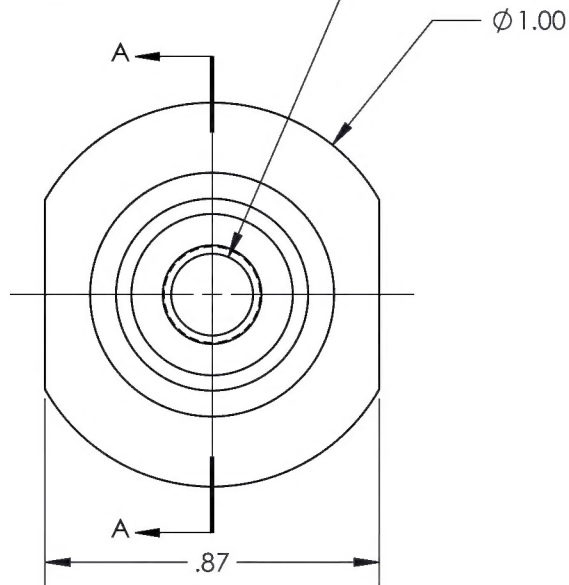
REMOVE & INSTALL TOOL

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-16	REV 3
MAT'L	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	MD 500D
SCALE 1:1	DATE 6/28/2000
	SHEET 6 OF 9

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0104	-17 DELETED DIMS .493, .420. ADDED DIM 43.6°. CORRECTED TYPO ON THREAD CALLOUT.	5/14/2015	DPD	JAG

1/4-28 UNF - 2B THRU ALL



SECTION A-A

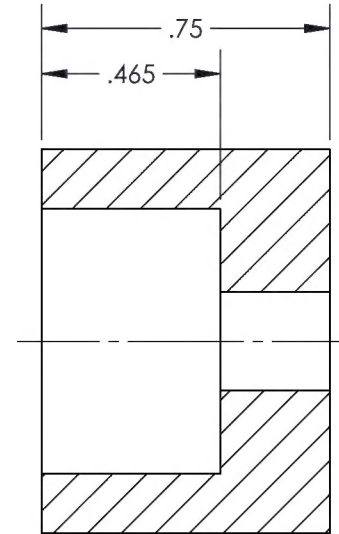
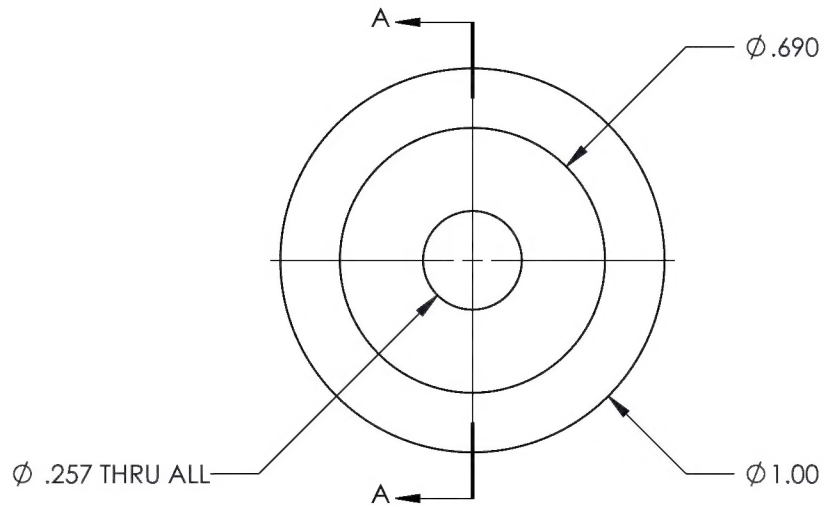
(-17)

R & I ADAPTER

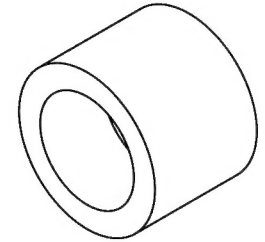
DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-17	REV 3
MAT'L STRESSPROOF	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	BLACK OXIDE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	MD 500D
SCALE 2:1	DATE 6/28/2000
	SHEET 7 OF 9

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



SECTION A-A



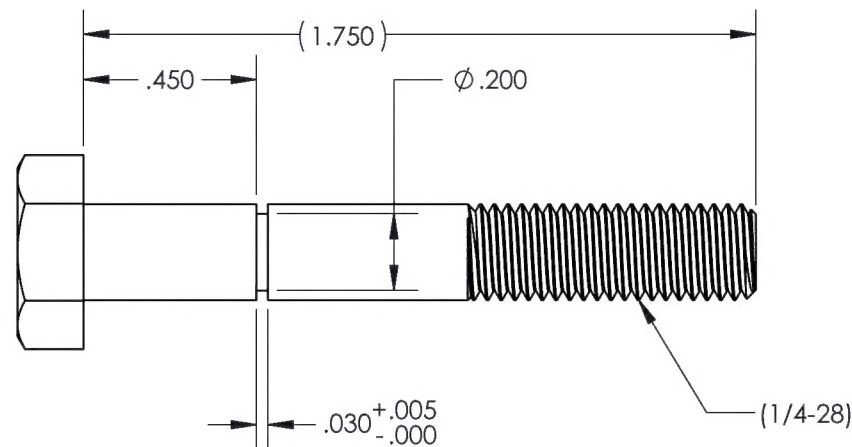
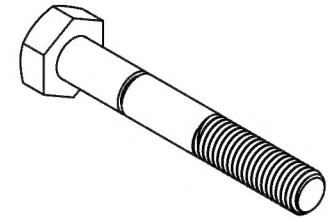
(-21)

CAP

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-21	REV 3
MAT'L 6061 T6	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	MD 500D
SCALE 2:1	DATE 6/28/2000
SHEET 8 OF 9	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0104	-27 CH'D DIM WAS .030 IS .030 +.005 -.000.	5/14/2015	DPD	JAG



(-27)

BOLT

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-27	REV 3
MAT'L STEEL	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	MD 500D
SCALE 2:1	DATE 6/28/2000
	SHEET 9 OF 9